

F-19-1

{B1} 79004-11

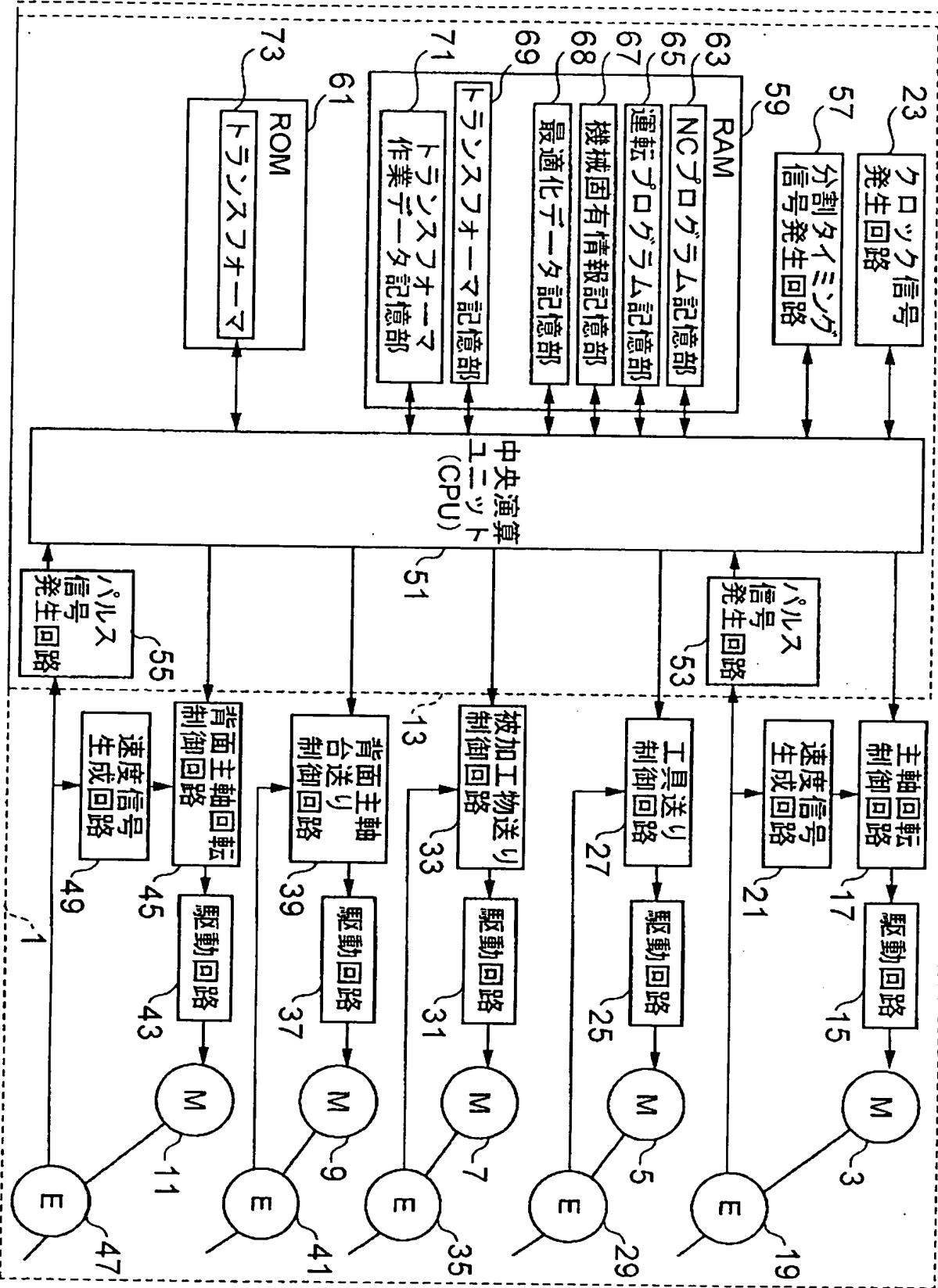


Fig - 2

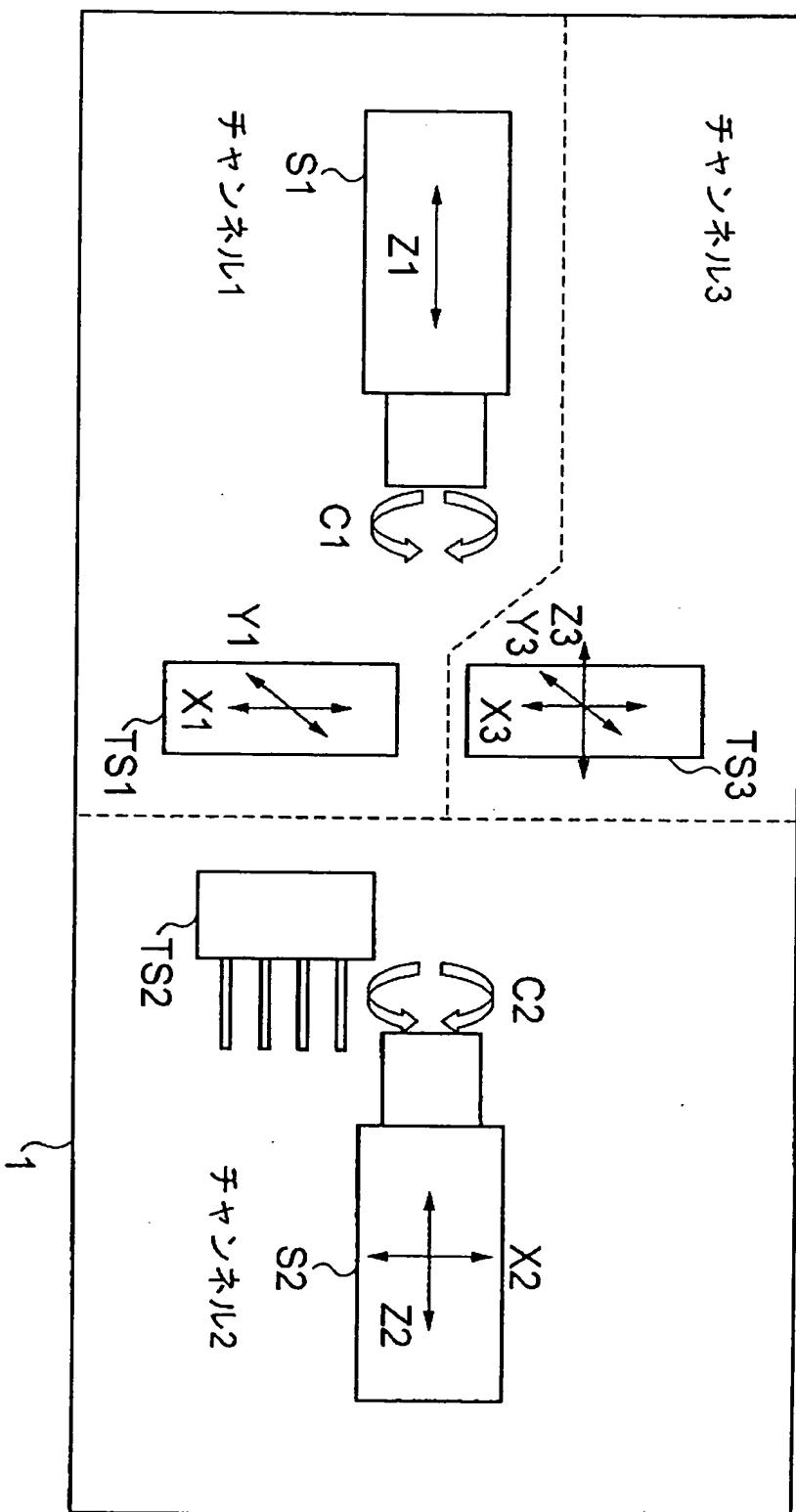
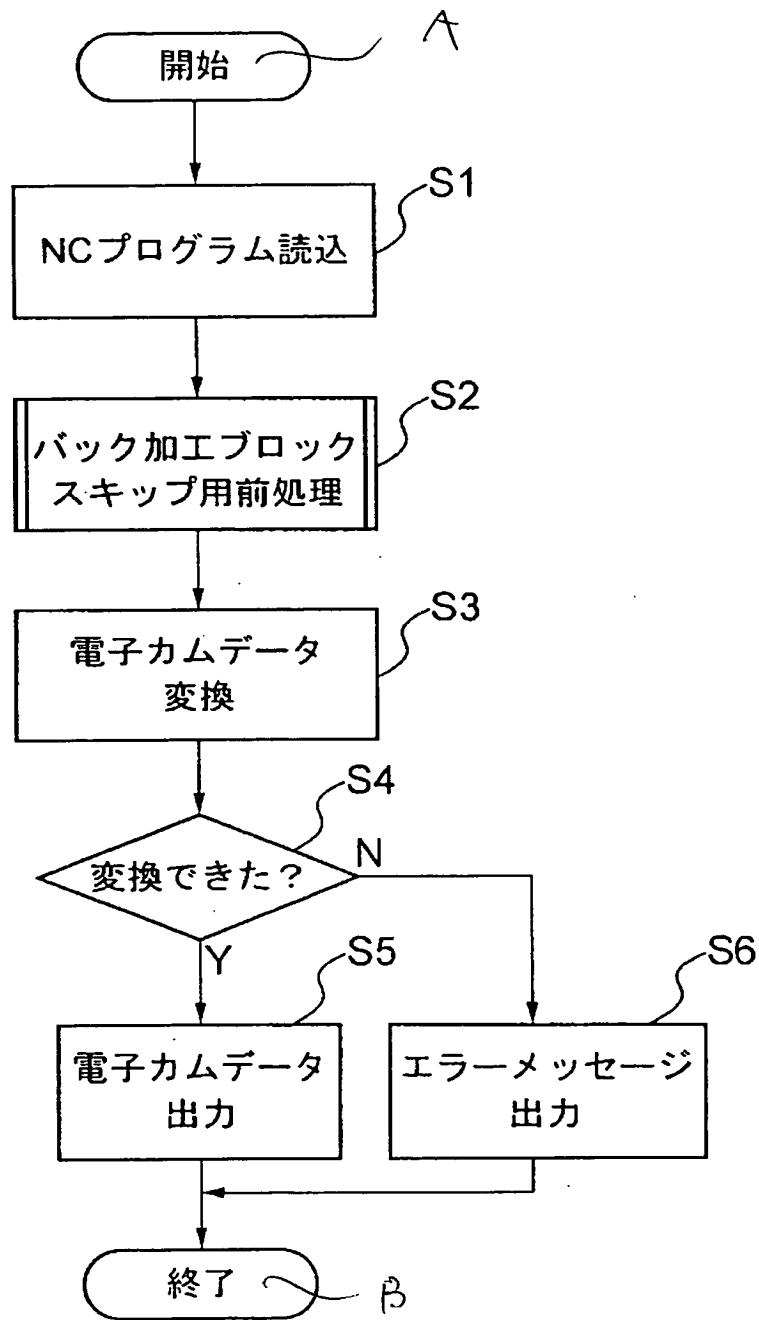


Fig-3

フローチャート



[Fig.4]

Fig. 4

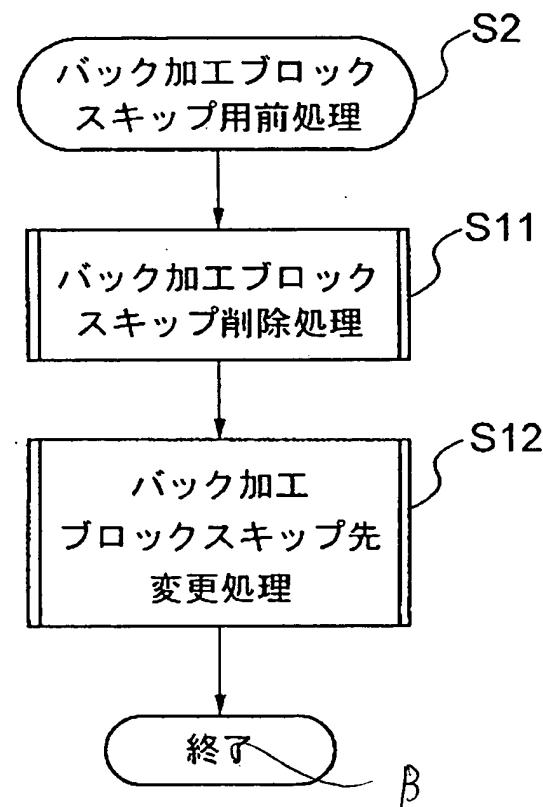


Fig. 5

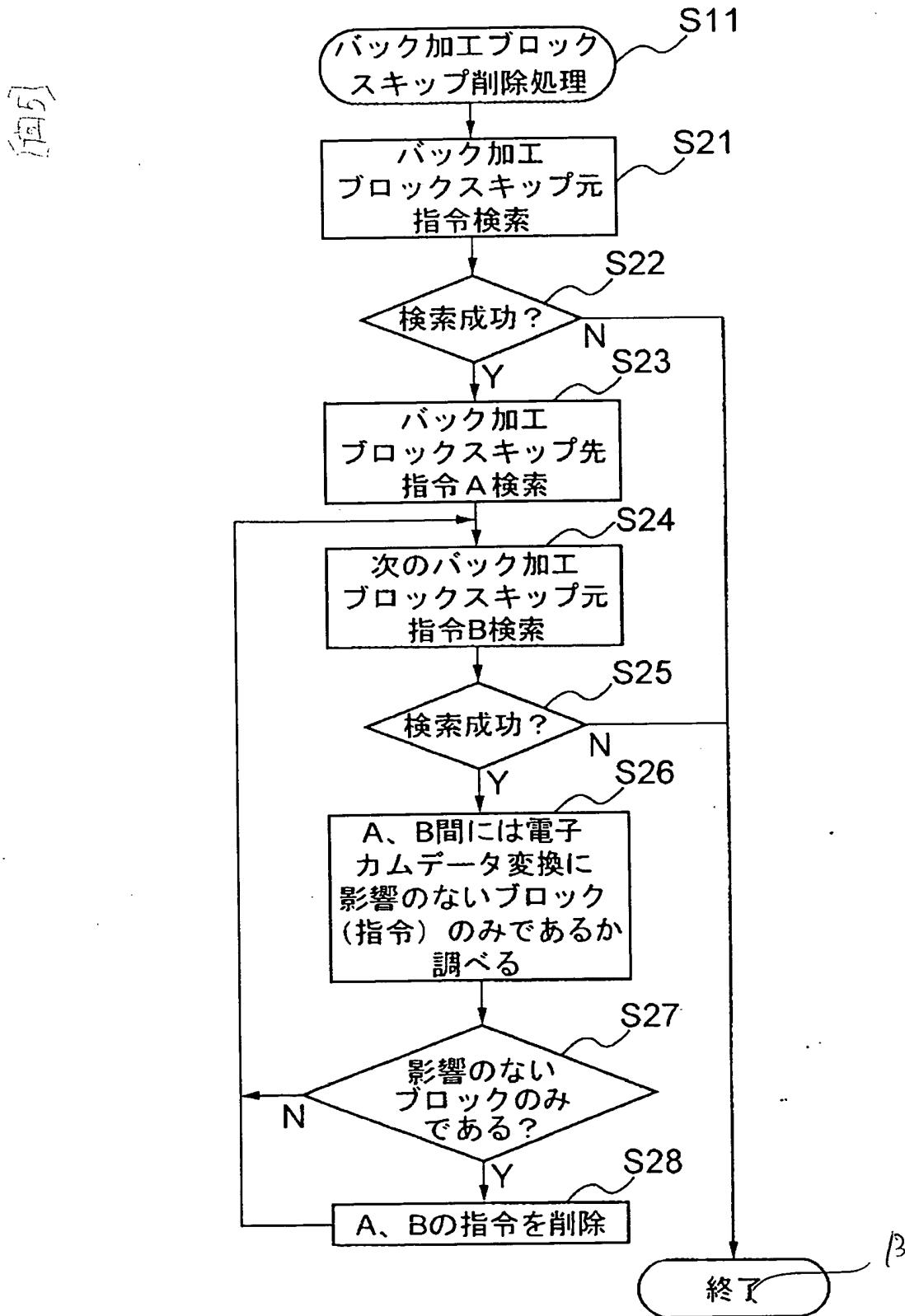


Fig. 6

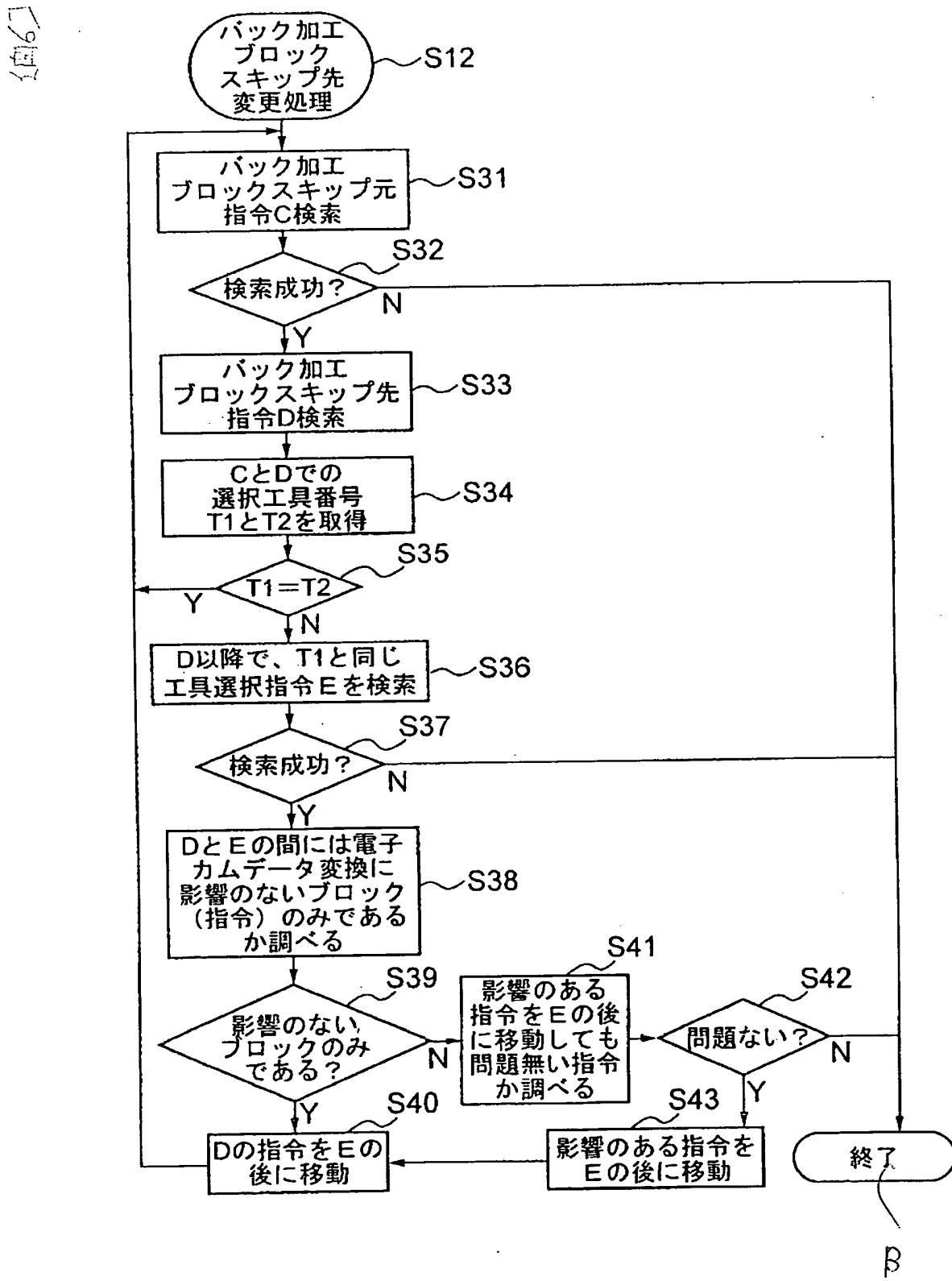


Fig - 7

17
18

CH1
TOP:
G0Z0.0

waitm (1,1,2,3)
M20
G0X10.0Z10.0
G28X60.0

CH3
TOP:

waitm (1,1,2,3)
M20
G28Z0.0

CH2
TOP:
G95
T2000
waitm (1,1,2,3)
M20
M75

N1
;msg ("DRILL")
T3800
wcs132
MS2
M3 S2000

waitm (2,2,3)
G28X60.0

EM75:
waitm (2,2,3)
M75
G0 Z-1
G1 Z3. F.05
G28 Z0

waitm (49,1,2,3)
M99
M30

waitm (49,1,2,3)
M99
M30

EM75:
M900
waitm (49,1,2,3)
T2000
M99
M30